

# PATENT ABSTRACTS OF JAPAN

(11)Publication number : 07-266575

(43)Date of publication of application : 17.10.1995

(51)Int.Cl.

B41J 2/175  
B41J 2/01

(21)Application number : 06-057554

(71)Applicant : SEIKO EPSON CORP

(22)Date of filing : 28.03.1994

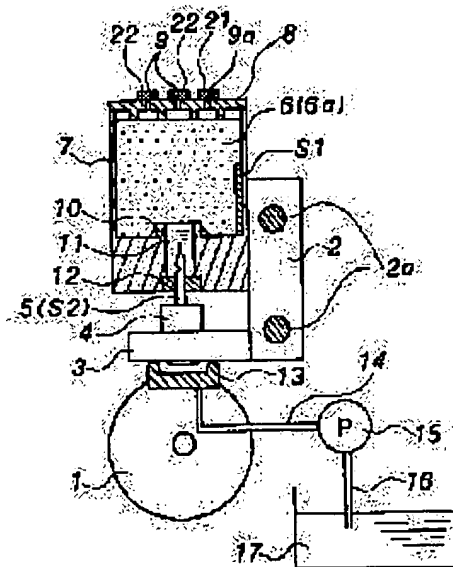
(72)Inventor : KOBAYASHI TAKAO  
KANETANI MUNEHIDE  
MIYAZAWA HISASHI  
MOCHIZUKI SEIJI  
KOIKE HISASHI  
SUDA KOJI

(54) INK JET RECORDING APPARATUS AND INK TANK AND MANUFACTURE THEREOF

(57)Abstract:

PURPOSE: To provide an ink jet recording apparatus capable of keeping the reliability even in the case of separating the recording head and ink tank.

CONSTITUTION: The ink jet recording apparatus comprises a communication part including an ink reservoir 6, an ink chamber 11 communicating to the recording head 3, and a blank cap 12, one or a plurality of communicating holes 9 made to communicate to the outside, and an impervious sealing member 21 for sealing each communicating holes 9 to be a decompressed state and permitting at least one to be openable immediately before being mounted on the ink jet recording apparatus, and further it comprises a vessel to be wrapped by making a space and in a decompressed state.



LEGAL STATUS

[Date of request for examination] 19.03.2001

[Date of sending the examiner's decision of rejection]

[Kind of final disposal of application other than the examiner's decision of rejection or application converted registration]

[Date of final disposal for application]

[Patent number] 3424313

[Date of registration] 02.05.2003

[Number of appeal against examiner's decision of rejection]

[Date of requesting appeal against examiner's decision of rejection]

[Date of extinction of right]

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(19) 日本国特許庁 (J P)

(12) 公開特許公報 (A)

(11) 特許出願公開番号

特開平7-266575

(43) 公開日 平成7年(1995)10月17日

(51) Int.Cl.<sup>6</sup>

識別記号

庁内整理番号

F I

技術表示箇所

B 4 1 J 2/175

2/01

B 4 1 J 3/ 04

1 0 2 Z

1 0 1 Z

審査請求 未請求 請求項の数5 O L (全 9 頁)

(21) 出願番号

特願平6-57554

(22) 出願日

平成6年(1994)3月28日

(71) 出願人 000002369

セイコーエプソン株式会社

東京都新宿区西新宿2丁目4番1号

(72) 発明者 小林 隆男

長野県諏訪市大和3丁目3番5号 セイコ

ーエプソン株式会社内

(72) 発明者 金谷 宗秀

長野県諏訪市大和3丁目3番5号 セイコ

ーエプソン株式会社内

(72) 発明者 宮澤 久

長野県諏訪市大和3丁目3番5号 セイコ

ーエプソン株式会社内

(74) 代理人 弁理士 鈴木 喜三郎 (外1名)

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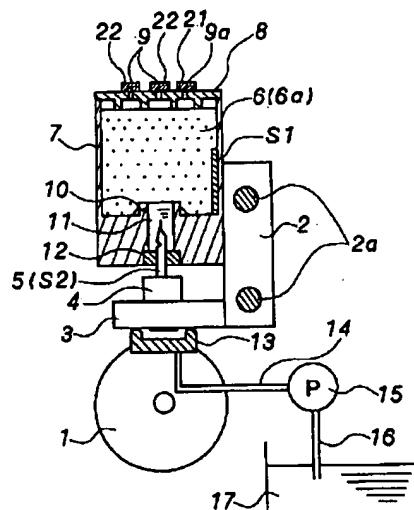
(54) 【発明の名称】 インクジェット記録装置及びインクタンクとその製造方法

(57) 【要約】

【目的】 記録ヘッドとインクタンクとを分離しても信頼性の高いインクジェット記録装置を提供する。

【構成】 インク溜り6と記録ヘッド3に連通するインク室11及び盲栓12よりなる連通部と、外部と連通するが如く穿たれた1個ないし複数個の連通孔9と、各々の連通孔9を減圧状態となるよう封止し、少なくとも1個がインクジェット記録装置に装填する直前に開封可能である非通気性の封止部材21から構成され、さらに空間を設けて減圧状態で包装される容器25からなる。

1: プラチフ  
2: キャリッジ  
3: 記録ヘッド  
4: フィルター室  
5: 中空針  
6: インク溜り  
6a: フォーム  
7: インクタンク  
9: 連通孔  
9a: 通気孔  
21: 封止部材  
22: 封止部材



【特許請求の範囲】

【請求項1】 インクタンクと、該インクタンクと連通部材を介して連通するインクジェット式記録ヘッドを有するインクジェット記録装置において、前記インクタンクは、インク溜りと、該インク溜りと前記記録ヘッドに連通する連通部と、外部と連通するが如く穿たれた1個ないし複数の連通孔と、各々の前記連通孔を減圧状態となるよう封止し、少なくとも1個が前記インクジェット記録装置に装填する直前に開封可能である非通気性の封止部材から構成され、さらに空間を設けて減圧状態で包装される容器からなることを特徴とするインクジェット記録装置。

【請求項2】 ノズルよりインク滴を吐出し記録紙に記録を行うインクジェット記録装置に装填し、記録ヘッドにインクを供給するインクタンクにおいて、該インクタンクは、インク溜りと、該インク溜りと前記記録ヘッドに連通する連通部と、外部と連通するが如く穿たれた1個ないし複数の連通孔と、各々の該連通孔を減圧状態となるよう封止し、少なくとも1個が前記インクジェット記録装置に装填する直前に開封可能である非通気性の封止部材から構成され、さらに空間を設けて減圧状態で包装される容器からなることを特徴とするインクタンク。

【請求項3】 インクジェット記録装置に用いる、インク溜りと、外部と連通するが如く穿たれた連通孔と、前記インク溜りと前記インクジェット記録装置に連通する連通部を有するインクタンクの製造方法において、  
A. 前記連通孔を通じて前記インク溜りを減圧する工程  
B. インクを前記連通孔から前記インクタンクに供給し充填する工程  
C. 少なくとも1個が開封可能である非通気性の封止部材で、各々の前記連通孔のうち、少なくとも1個はインク溜りが減圧状態となるよう、減圧し密封をする工程  
D. 前記インクタンクを通気性のない容器内に入れ、該容器内を減圧し密封包装する工程  
からなることを特徴とするインクタンクの製造方法。

【請求項4】 前記CとDの工程が、0.02～0.05MPaのほぼ同圧下で行われることを特徴とする請求項3記載のインクタンクの製造方法。

【請求項5】 前記連通孔の少なくとも1個を、大気圧下で非密封に封止部材を仮止めし、減圧状態で本止めし、さらに容器内に減圧状態で密封にする工程からなることを特徴とする請求項3記載のインクタンクの製造方法。

【発明の詳細な説明】

【0001】

【産業上の利用分野】 本発明はノズルよりインク滴を吐出して記録紙上に文字などの記録を行うインクジェット記録装置に関する。

【0002】

【従来の技術】 ノズルよりインク滴を吐出させて記録紙上に、記録情報に応じた文字などの記録書き込みを行うインクジェット記録装置では、微細なノズルからインクを吐出してインク滴を形成する。インク滴の形成は記録ヘッド内部に配設された圧力室を電気至振動子、電気熱変換素子等により急激に容積変化させ、吐出圧力を発生することで行われる。そのためインク供給経路内に空気が混入した場合には、吐出圧力が良好に発生せず、記録書き込みが不能となる。

【0003】 さらに、インクタンク内のインクが消費され尽くして供給が断たれると、記録書き込みが不能になる。そして、ノズルに至るインク供給経路内に空気が入り込み、インクを新たに補給しても記録書き込みが可能になるまでに、多大の時間とインクがかかってしまうといった問題が生じる。

【0004】 もとより、このような問題に対処するために、インクタンク内にレベル検出器を配設し、またはインク供給経路の一部にレベル検出器を配設しインクの供給が断たれる前にインクエンドを検出する構成が用いられている。それによりインクエンド時にインク供給経路内に空気が大量に混入することを防止している。しかしながらインクタンクの交換時等のインクタンクと記録ヘッドとの抜き差し時にインク供給経路内に空気が混入することを完全に防止することはできない。

【0005】 そこで従来よりインク供給経路内に混入した空気の影響を、インクタンクと記録ヘッドとの抜き差し時に初期的に抑えるための提案として、特公平3-61592号公報に記載されたものなどが知られている。ガスバリア性の極めて高い密封容器内に、脱気したインクを収容したインクタンクを減圧状態で収容したものである。この従来例では、密封容器を開封直後はインクタンク内のインクは脱気インクとなっており、この脱気インクによりインク供給経路内に混入した空気の影響を初期的に除去しようとするものである。

【0006】 しかし、この密封容器構造は、インクタンクの姿勢差、位置、接続性等で、自由度がなく、複雑である。またキャリッジの動作に伴って、インクが激しく揺動し、記録ヘッドの吐出特性に不具合を生ずる。

【0007】 これを解決するために、多孔質部材を収納したインクタンクが提案されている。このインクタンクには、インクを充填するための注入孔や、インクの使用による減少に対応して空気が流入するように、大気と連通するための通気孔を有する。

【0008】 また前記のように脱気インクにするため、減圧状態でインクを充填し、さらに、インクタンクを減圧状態で容器内に包装させる。

【0009】

【発明が解決しようとする課題】 しかし従来例では、インクの表面張力が比較的高くて、泡立ちにくい場合はよいが、より減圧度が大きく、脱気度を保ち、信頼性を高

めようとした場合、あるいはインクの表面張力が低く、泡立ちやすい場合には、インクが注入孔から漏れやすくなる。また、落としたりといった衝撃を加えた後に減圧包装すると、僅かな減圧でインクが漏れるので作業性が悪い。さらに温度変化があるとインク中の気体の膨張で、インクが漏れる。インクの漏れを防止するためにインクの充填量を減らして充填効率を落とすとインクタンクが大きくなるといった問題がある。

【0010】また、インクタンク中に空間を設けたり、蓋の形状を工夫して漏れの対策をしても、高温環境下ではインク中の気体が膨張して漏れてしまい、これを完全に防ぐことは難しい上に、インクタンクが大きくなるといった問題がある。

【0011】そこで本発明はこのような問題点を解決するものでその目的とするところは、信頼性が高く小型のインクジェット記録装置を提供することにある。

【0012】

【課題を解決するための手段】本発明のインクジェット記録装置は、インクタンクから連通部材を介してインクを供給し、ノズルよりインク滴を吐出し記録紙に記録を行うインクジェット記録装置において、インクタンクは、インク溜りと、インク溜りと記録ヘッドに連通する連通部と、外部と連通するが如く穿たれた1個ないし複数個の連通孔と、各々の該連通孔を減圧状態となるよう封止し、少なくとも1個がインクジェット記録装置に装填する直前に開封可能である非通気性の封止部材から構成され、さらに空間を設けて減圧状態で包装される容器からなることを特徴とする。

【0013】本発明のインクタンクは、ノズルよりインク滴を吐出し記録紙に記録を行うインクジェット記録装置に装填し、記録ヘッドにインクを供給するインクタンクにおいて、インクタンクは、インク溜りとインク溜りと記録ヘッドに連通する連通部と、外部と連通するが如く穿たれた1個ないし複数個の連通孔と、各々の該連通孔を減圧状態となるよう封止し、少なくとも1個がインクジェット記録装置に装填する直前に開封可能である非通気性の封止部材から構成され、さらに空間を設けて減圧状態で包装される容器からなることを特徴とする。

【0014】本発明のインクタンクの製造方法は、インクジェット記録装置に用いる、インク溜りと、外部と連通するが如く穿たれた連通孔と、インク溜りとインクジェット記録装置に連通する連通部を有するインクタンクの製造方法において、

- A. 連通孔を通じて該インク溜りを減圧する工程
- B. インクを連通孔からインクタンクに供給し充填する工程
- C. 少なくとも1個が開封可能である非通気性の封止部材で、各々の連通孔のうち、少なくとも1個はインク溜りが減圧状態となるよう、減圧し密封をする工程
- D. インクタンクを通気性のない容器内に入れ、容器内

を減圧し密封包装する工程

からなることを特徴とする。

【0015】また前記CとDの工程が、0.02～0.05MPaのほぼ同圧下で行われることを特徴とする。

【0016】さらに連通孔の少なくとも1個を、大気圧下で非密封に封止部材を仮止めし、減圧状態で本止めし、容器内に減圧状態で密封にする工程からなることを特徴とする。

【0017】

【作用】本発明の上記の構成によれば、インクタンクを減圧状態で密封することから、インクが再脱気されるとともに、減圧包装時や輸送時や保存状態でのインクの漏れがなくなる。またインクタンクと密封容器間に空間を設けて減圧包装したので、インクタンク内部よりインクの分解で発生したガスも、ケースを通して徐々に減圧包装内に吸収され、それによりインクタンクの使用初期に大変信頼性の高い状態に脱気される。これによりインクタンクの交換時にインク供給路内に混入してしまう空気による不具合を解消する。

【0018】また減圧されたインクタンクを包装前に目視確認できることから、インク漏れ、ケースの変形等の工程検査が容易になる。

【0019】さらに、非通気性の封止部材で、インクタンク7の上面を覆うことにより、実使用時のインク蒸発を最小限に抑えられる。

【0020】

【実施例】以下に本発明の一実施例を図面にもとづいて説明する。

【0021】図1は本発明のインクジェット記録装置の一実施例を説明するための主要断面図であり、図2は本発明のインクジェット記録装置に用いるインクタンクの主要部の分解斜視図である。図3は主要部の斜視図を示したものである。また図4は、インクエンド検出回路を説明するためのブロック図である。記録紙を搬送するために矢印A方向に回転する記録紙搬送手段であるプラテン1に沿って、ガイド軸2a上を矢印B方向に往復運動するキャリッジ2には、プラテン1に近接して記録ヘッド3が一体的に設けられている。記録ヘッド3の上方には、インク溜り6があり内部にポリウレタンフォーム等の多孔質部材よりなるフォーム6aを収容したインクタンク7が設けられている。本実施例においてインクタンク7は6Y、6M、6Cの3つの部屋に分割されて、インク溜り6は3つ設けられている。この部屋各々にはイエロー、シアン、マゼンタのカラーインクが充填されている。ただしインクの種類と数が設計上変わればインクタンク7内の部屋数は必要数に分割されることになる。インクタンク7には、その蓋8に外部と連通する連通孔9が設けられ、またその底面にはフォーム6aとの密着をはかる台状の突起10が形成されている。この突起10の中心部から下方に向けて記録ヘッド3に連通する連

通部がある。連通部はフォーム6 a 内のインクを取り出し保持するインク室1 1と、インク室1 1の端部にゴム等の弾性部材よりなる盲栓1 2により形成されている。そして、この盲栓1 2にフィルタ室4を介して、記録ヘッド3と連通する連通部材である中空針5を挿通することにより、インクタンク7内に含浸したインクを記録ヘッド3に供給するように構成されている。なお、インク室1 1は盲栓1 2及びフォーム6 aにより密閉室の状態になっている。また、連通孔9の少なくとも1つは開封可能な非通気性の封止部材2 1で使用直前までは封止されていて、使用直前に開封して通気孔9 aとなる。但し、本実施例では連通孔9は複数個設けてあるが、各部屋1つだけでも所望の効果を得るのに何等問題はない。開封するためには図2のように十分に長い封止部材2 1を用い、その端部を引っ張り剥して開封する方法を用いると容易に開封できる。さらに、その端部を容器2 5内に接合すれば容器2 5から取り出すときに必ず開封され、使用者の開封忘れなどの問題もなく確実に開封できる。また図5のようにインクタンクを取り付けるためのレバー3 0に突起3 1を設け、インクタンクを取り付けるときにレバー3 0をC方向に倒し、この突起3 1で突き破る方法を用いても容易に開封できる。但し、封止部材2 1を開封できる構成であれば、特に専用の器具を用いて開封しなくてもよい。開封しない他の連通孔9にも非通気性の封止部材2 2を設けてある。

【0022】ここで封止部材2 1を開封して通気孔9 aを開ける理由を説明する。全ての封止部材2 1, 2 2は非通気性のため、通常のプリンタ使用のインク消費スピードに対して、インクタンク内に補充される空気量が少ないので、プリンタを使用するにつれて徐々にインクタンク内が負圧になる。この負圧が一定値を越えると、つまりヘッドのノズルに形成されるインクのメニスカスの毛細管力を越える負圧がインクタンク内に発生すると、メニスカスは破壊しインク滴の吐出不良となってしまう。従って、インクの消費に対応して空気を補充するための通気孔9 aが必要となる。

【0023】また万一、記録ヘッド3に吐出不良が生じた場合には、キャップ1 3、配管1 4を介して吸引ポンプ1 5を動作することで、記録ヘッド3よりインクを吸引する。それにより、吐出不良の回復動作が行われる。吸引されたインクは配管1 6を通して廃インク溜1 7に送られる。本発明においては、廃インク溜1 7とインクタンク7とは別体であって廃インク溜1 7は記録装置本体内に配設され、通常は交換されない構成になっている。

【0024】ところで図中符号S 1, S 2は、インクエンド検出用の電極であって、その一方の電極S 1はフォーム6 aと接触するようにインクタンク7の内壁面に設けられ、他方の電極S 2は、インクと接触する中空針5が電極を兼ねている。電極S 1とインクタンク7の間に

は、インクが漏れないようにゴム製のOリング2 4がかませている。そして電極S 1には、図4に示したように基準電圧Vccが印可される。また他方の電極S 2を兼ねる中空針5は接地されている。さらに基準電圧Vccが印可されている側の電極S 1には、微分回路1 9と比較回路2 0とからなる抵抗変化量検出回路が接続している。そして抵抗変化量がある一定レベルを越えたときに、出力信号を発生するように構成されている。

【0025】また記録ヘッド3に印可されるインク滴吐出用の記録指令信号は、可とう性の信号伝達手段であるFPC (Flexible Print Circuit) 18により伝達される。そしてFPC 18上にはインクエンド検出用の信号線が一体的に配線され、電極S 1, S 2に接続されている。なお、信号伝達手段としてFPC 18の代わりに、FFC (Flexible Flat Cable) 等を用いても良いことはいうまでもない。さらに1枚のFPCではなく、2枚重ねの構成であっても良いことはいうまでもない。

【0026】次に本実施例に用いたインクタンクの製造方法について図6のフローチャートにより説明する。

【0027】インクタンク組立工程では、前述図2の構成からなるインクタンク7を封止部材2 1, 2 2を残して組み立てる。

【0028】インク溜まり減圧工程では、インクタンク7のインク溜まり6を連通孔9を通して、0. 04 MPa以下に減圧する。この時の減圧度は、充填インク量及び充填時間を考慮すると0. 02 MPa以下が望ましい。

【0029】その後、インク充填工程で連通孔9よりインクを充填する。この時インクは減圧され、脱気インクとなる。この減圧状態で多孔質部材にインクを充填する方法については特開昭60-245560号公報において開示され説明されているように、インク充填効果は非常に高い方法である。

【0030】次に大気圧下で連通孔9のうち9 a以外を封止部材2 2で封をする。その後、減圧密封工程でインクタンク7を0. 02~0. 05 MPaの減圧下にし、通気孔9 aを封止部材2 1で封をする。この減圧下であれば、インクは十分再脱気され、通気孔9 aからのインク漏れはない。減圧度を0. 02 MPa以下にすると、減圧時のインク漏れ、あるいは前述の密封後のわずかな衝撃、姿勢差、環境温度変化等でインク漏れが起きる。

【0031】封止後大気開放する。この工程は図7のように、封止部材2 1の2 1 aを大気下で仮止めし、0. 02~0. 05 MPaの減圧下で2 1 b本止めしてもよく、この方が装置上容易である。

【0032】このようにして密封されたインクタンク7のインクは、充填後の大気開放及び再減圧で、多孔質部材のフォーム6 aに均一に充填されるとともに、再脱気される。

【0033】封止方法には溶着もしくは接着材による方法などを用いることができるが、インクの漏れを防ぐためには溶着の方が望ましい。接着剤を用いる場合、漏れを防ぐための接着力と剥離性、インクに犯されないといった特性を満足する必要がある。

【0034】封止部材21、22は、非通気性の部材で、ポリエチレンテレフタレート樹脂あるいはアルミラミネートフィルムを主体とし、溶着あるいは接着しやすいポリスチレン樹脂やポリオレフィン系樹脂等からなる積層フィルムである。

【0035】次に減圧包装工程では、図8のようにインクタンク7とスぺーサ28を容器25に入れ0.02～0.05MPaに減圧した後、完全にシール部26をシールし密封包装する。その後大気開放する。

【0036】インクタンク7と容器25の間には空間29がある。この空間29によって、インクタンク7の輸送中や保存中にインクが分解して窒素や酸素などのガスが発生してもケース壁を通して徐々に脱気される。スぺーサ28に段ボールやウレタンフォームのように空気を透過し、かつその内部に空間が存在する部材を用いれば、もし容器25が密着しても部材内の空間が空間29の役割を果たす。またインクタンク7を保護する緩衝材としての役割も果たす。減圧包装時の減圧度は前記封止部材21の封止時減圧度とほぼ同じ0.02～0.05MPaである。これによりインクタンク内と密封容器内の圧力バランスが保たれ、インクタンク7に溶着あるいは接着した封止部材21、22の接合強度が小さくても、剥がれることはない。

【0037】図9に減圧密封包装された密封容器を示す。容器25は、ガスバリア性の極めて高いアルミラミネートフィルムで作られた包装袋である。

【0038】さらに梱包工程で梱包箱27（不図示）に収納される。この状態で容器25のシール部26は梱包箱27との間にあって緩衝材を兼ねている。そのため特別な緩衝部材を用いる必要はない。

【0039】次に減圧包装時の真空度と減圧包装状態における保存期間後の窒素量との関係を説明する。大気中には窒素以外の気体も存在するが、窒素量が最も大きいので窒素量がコントロールできればよい。

【0040】実験によれば表1に示すように密封シール時の減圧度を制御することにより、包装を開封した直後のインクタンク7内のインクの脱気度を制御することができる。

【0041】

【表1】

減圧度 (MPa)	窒素量 (%)
0.05	60～70
0.035	55～65
0.02	45～60

【0042】表中の窒素量は、飽和値に対するインク中に溶けている窒素量のパーセンテージで示しており、本実施例に用いたインクの場合には、飽和値は10～11ppm程度であった。

【0043】次に製造時から実使用までのインクタンク内のインク脱気度がどのように変化するかをインク中の窒素量に実験データに基づき図10で説明する。インク充填後のa時点で脱気されていたインクは、大気状態に放置されることにより、約3日後のb時点で飽和状態に達する。c時点で0.02～0.05MPaの減圧下でインクタンク7を非通気性の封止部材21で密封すると、インクは脱気し、さらにインクタンク7の空間23にインクに溶解の窒素や酸素が吸収され、d時点の脱気度までになる。その後は、インクが分解して、インク成分中の窒素等のガスが発生することもあり、脱気度が落ちる。d時点までの期間は、周辺環境にもよるが、1日程度であり、e時点には6ヶ月から1年かけて10～20%増加していく。e時点で減圧包装すると、インクタンク7のインク脱気度はインクタンク7のケース等を通して徐々に向上する。長期間中に発生するインクからのガスも、空間29に十分吸収させることができる。e時点からf時点までの期間は、包装状態での保存期間であり、実験では2年間を想定した。

【0044】そして開封後の図中f時点より順次窒素量は上昇する。インク中の窒素量は、開封後3日程で図中gの略飽和状態に達する。しかしながら実験によると、脱気による効果は図中fの開封後から2～4週間程度期待できることがわかった（図中h）。その後は完全飽和状態となり、本発明で所望するインクの脱気の効果はなくなる。

【0045】本実験では、各時点まで十分な期間を設けて行ったが、実製造工程では、a時点のインク充填後、数時間以内にc時点の減圧下封止をし、さらに1日以内にe時点の減圧包装を行なうため、図示のようなN2値の変化は見られず、脱気度が十分保たれた状態で減圧包装される。

【0046】ここでインクの脱気による効果について説明する。インクタンク7を中空針5に対して抜き差しする際に、中空針5より混入する空気の量は、通常は非常に微量である。実験による確認では、中空針5のインク流入口径が直径0.8mm程度の時、混入する空気の量は、多くてもメニスカス分の0.4立方mm程度以下で

あった。一度混入した空気は記録ヘッド3に向かって流れ、フィルタ室4内のフィルタ4a（不図示）に到達しトラップされる。このトラップされた空気はフィルタ4aの目粗さが非常に微細なため容易にフィルタ4aを通過することはない。実験によればフィルタ4aの直径が4mm、フィルタ室4内の空間幅が0.3～0.5mm程度の時にインクタンク7の抜き差し回数が10～数100回行なっても記録動作によって該空気がフィルタ4aを通過することはなかった。この程度の空気の混入であれば図10中gまでの期間中は、明らかに脱気インクを記録ヘッド3に供給することができ、それによりインクタンク7を中空針5に対して抜き差しする際に、中空針5より混入した空気はインクにとけ込み問題とはならない。しかしながら実使用においては中空針5よりインクタンク7を外したまま放置される場合などは充分に有り得る。この場合には大量に空気が混入する。大量に空気が混入すると混入した空気はフィルタ4aをふさぎインクの通過を妨げてしまう。その結果として記録ヘッド3は吐出不良となる。この場合には吸引ポンプ15を動作して吐出不良の回復動作を行うのであるが、インクの脱気度によって回復性に大きな差があることも実験によりわかった。図10中hで示す開封後2～4週間程度までのインクであれば、フィルタ室4内の空気を吸引ポンプ15により吸引除去するのに何ら不具合はない。ところがこの期間を過ぎるとインク中の空気量は完全飽和、さらには過飽和状態となり、空気と共にフィルタ4aを通過するとフィルタ4aから記録ヘッド3にかけて微小気泡が発生することが確認された。この微小気泡が記録ヘッド3の圧力室にある場合には吐出不良となってしまう。

【0047】以上説明したようにインクタンク7の交換時に混入する空気に対しては、インクの脱気の効果により吐出不良となるような不具合をなくすことができる。またフィルタ室4内に多量に空気が溜った場合に行う回復動作においてもインクの脱気の効果により、良好に回復動作を終了することができる。フィルタ室4内の空気量が一定以下であれば空気がインクと共にフィルタ4aを通過しないため、図10中g以降の飽和状態となったインクであっても回復動作時になんら不具合はない。

【0048】

【発明の効果】本発明によれば、インクタンクを減圧状態で密封することから、インクが再脱気されるとともに、減圧包装時や輸送時や保存状態でインクの漏れがなくなる。またインクタンクと密封容器間に空間を設けて減圧包装したので、インクタンク内部よりインクの分解で発生したガスも、ケースを通して徐々に減圧包装内

に吸収され、それによりインクタンクの使用初期に大変信頼性の高い状態に脱気されたインクを記録装置に供給することができる。これによりインクタンクの交換時にインク供給路内に混入してしまう空気による不具合を解消する。

【0049】また減圧されたインクタンクを包装前に目視確認できることから、インク漏れ、ケースの変形等の工程検査が容易になる。

【0050】さらに、非通気性の封止部材で、インクタンク7の上面を覆うことにより、実使用時のインク蒸発を最小限に抑える効果もある。

【0051】以上により極めて信頼性が高く小型のインクジェット記録装置を提供できる。

【図面の簡単な説明】

【図1】本発明のインクジェット記録装置の一実施例を説明するための主要断面図。

【図2】本発明のインクジェット記録装置に用いるインクタンクの主要部の分解斜視図。

【図3】本発明のインクジェット記録装置の主要部の斜視図。

【図4】インクエンド検出回路を説明するためのブロック図。

【図5】本発明のインクジェット記録装置の主要部の斜視図。

【図6】本発明の製造工程を説明するフローチャート。

【図7】本発明の封止部材による封止を説明する斜視図。

【図8】減圧包装容器内を説明するための断面図。

【図9】減圧包装されたインクタンクを説明するための斜視図。

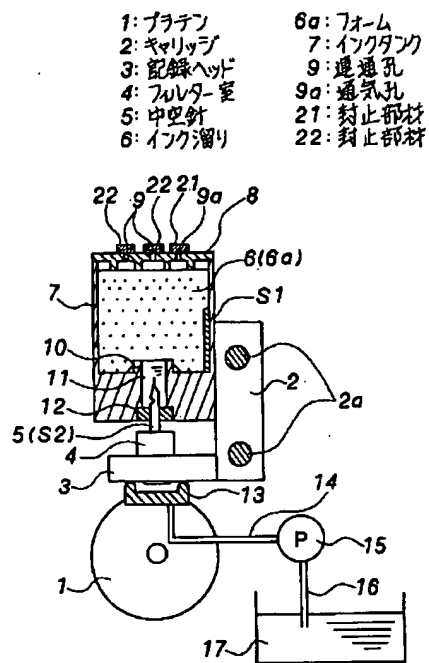
【図10】窒素量と時間の関係を示した図。

【符号の説明】

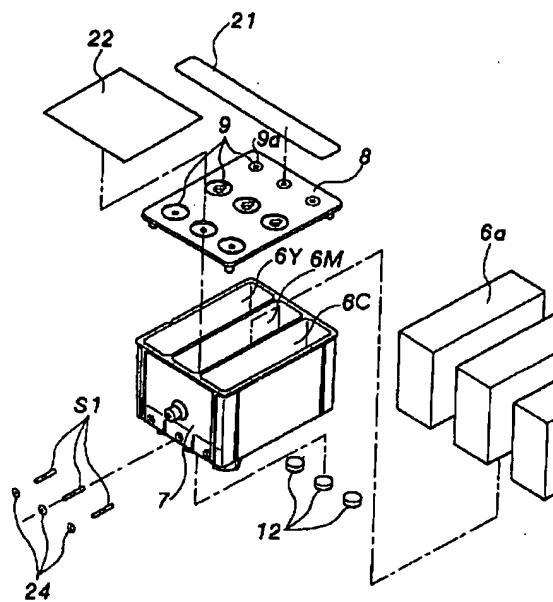
3・・・記録ヘッド  
6・・・インク溜まり  
6a・・・フォーム  
7・・・インクタンク  
9・・・連通孔  
9a・・・通気孔  
21・・・封止部材  
22・・・封止部材  
23・・・空間  
25・・・容器  
26・・・シール部  
28・・・スペーサ  
29・・・空間



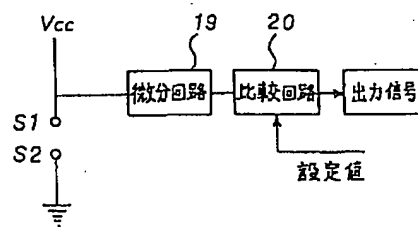
【図1】



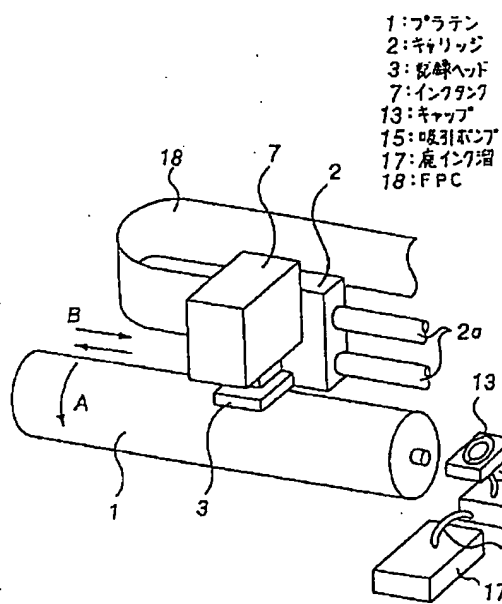
【図2】



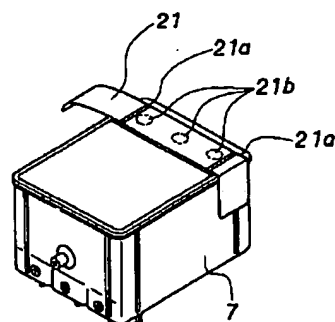
【図4】



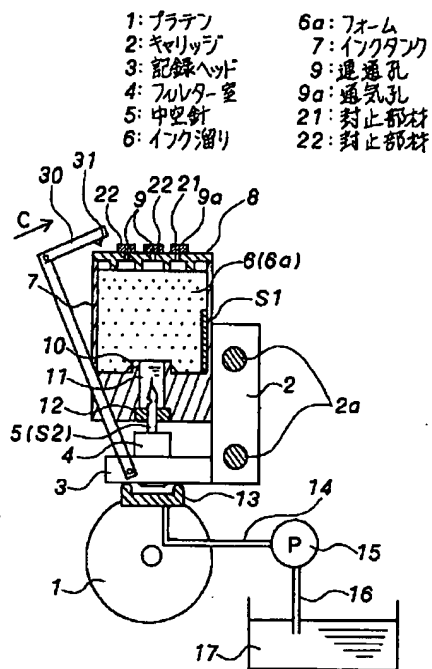
【図3】



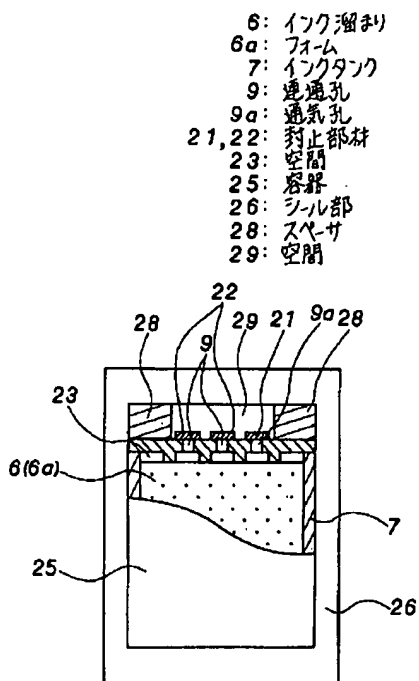
【図7】



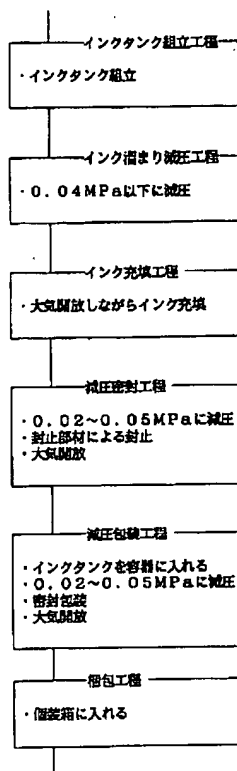
【図5】



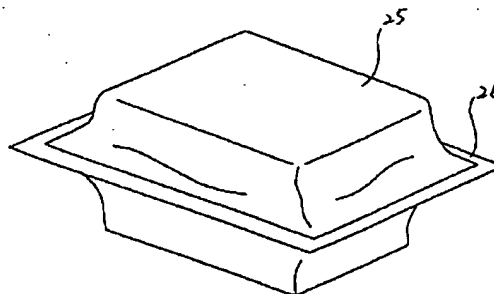
【図8】



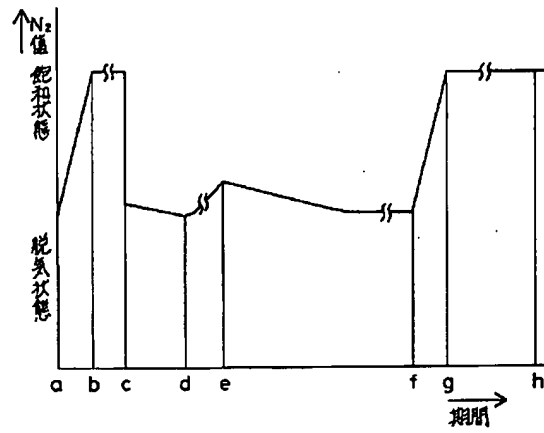
【図6】



【図9】



【図10】



フロントページの続き

(72)発明者 望月 聖二  
長野県諏訪市大和3丁目3番5号 セイコーエプソン株式会社内

(72)発明者 小池 尚志  
長野県諏訪市大和3丁目3番5号 セイコーエプソン株式会社内

(72)発明者 須田 幸治  
長野県諏訪市大和3丁目3番5号 セイコーエプソン株式会社内

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## CLAIMS

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[Claim(s)]

[Claim 1] In an ink tank, this ink tank, and the ink jet recording device that has the ink jet type recording head which is open for free passage through a free passage member said ink tank Ink \*\*\*\*, this ink \*\*\*\*, and the free passage section that is open for free passage to said recording head, One piece thru/or two or more free passage holes dug so that it might be open for free passage with the exterior, and each the hole of said free passage are closed so that it may be in a reduced pressure condition. The ink jet recording device characterized by consisting of a container which consists of closure members of the non-permeability which can be opened just before at least one piece loads said ink jet recording device, prepares space further, and is packed in the state of reduced pressure.

[Claim 2] In the ink tank which loads with an ink droplet the ink jet recording device which records on the discharge detail paper, and supplies ink to a recording head from a nozzle this ink tank Ink \*\*\*\*, this ink \*\*\*\*, and the free passage section that is open for free passage to a recording head in the first half, One piece thru/or two or more free passage holes dug so that it might be open for free passage with the exterior, and this each free passage hole are closed so that it may be in a reduced pressure condition. The ink tank characterized by consisting of a container which consists of closure members of the non-permeability which can be opened just before at least one piece loads said ink jet recording device, prepares space further, and is packed in the state of reduced pressure.

[Claim 3] In the manufacture approach of an ink tank of having the free passage section which is open for free passage to ink \*\*\*\* used for an ink jet recording device, the free passage hole dug so that it might be open for free passage with the exterior, and said ink \*\*\*\* and said ink jet recording device A. -- process C. which supplies and fills up said ink tank with the process B. ink which decompresses said ink \*\*\*\* through said free passage hole from said free passage hole -- by the closure member of the non-permeability which can open at least one piece It is the manufacture approach of the ink tank characterized by at least one in each the hole of said free passage consisting of a process which puts in the process D. aforementioned ink tank which seals by decompressing in a container without permeability so that ink \*\*\*\* may be in a reduced pressure condition, decompresses the inside of this container, and carries out a seal package.

[Claim 4] The manufacture approach of an ink tank according to claim 3 that said process of C and D is characterized by the thing of 0.02-0.05MPa mostly performed by this draft.

[Claim 5] The manufacture approach of the ink tank according to claim 3 characterized by consisting of a process which carries out this stop of the closure member to un-sealing in the state of a tacking meal and reduced pressure under atmospheric pressure, and makes seal further at least one of said free passage hole in the state of reduced pressure into a container.

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## DETAILED DESCRIPTION

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[Detailed Description of the Invention]

[0001]

[Industrial Application] This invention relates to the ink jet recording device which breathes out

Publ'n No.: JP 07-266575 Publ'n Date: 17.10.1995

an ink droplet and records an alphabetic character etc. in the record paper from a nozzle.

[0002]

[Description of the Prior Art] From a nozzle, an ink droplet is made to breathe out, with the ink jet recording device which performs record writing, such as an alphabetic character according to recording information, ink is breathed out in the record paper from a detailed nozzle, and an ink droplet is formed in it. Formation of an ink droplet carries out volume change of the pressure room arranged in the interior of a recording head rapidly by electrostriction vibrator, an electric thermal-conversion component, etc., and is performed by generating a discharge pressure. Therefore, when air mixes in an ink supply path, a discharge pressure does not occur good but record writing becomes impossible.

[0003] Furthermore, record writing will become impossible, if all the ink in an ink tank is consumed and supply is cut off. And air enters in the ink supply path of resulting in a nozzle, and the problem of applying a great quantity of time amount and ink by the time record writing is attained, even if it newly supplies ink arises.

[0004] In order to cope with such a problem from the first, before arranging a level detector in an ink tank, or arranging a level detector in a part of ink supply path and cutting off supply of ink, the configuration which detects an ink end is used. It has prevented that air mixes in a large quantity in an ink supply path by that cause at ink and the time. However, it cannot prevent thoroughly that air mixes in an ink supply path at the time of extraction and insertion with the ink tanks at the time of exchange of an ink tank etc., and a recording head.

[0005] Then, what was indicated by JP,3-61592,B is known as a proposal for suppressing the effect of the air conventionally mixed in the ink supply path in first stage at the time of extraction and insertion with an ink tank and a recording head. The ink tank which held the deaerated ink in the very high hermetic container of gas barrier property is held in the state of reduced pressure. In this conventional example, immediately after opening a hermetic container, the ink in an ink tank is deaeration ink, and it is going to remove the effect of the air mixed in the ink supply path in this deaeration ink in first stage.

[0006] However, it is the position difference of an ink tank, a location, connectability, etc., and this hermetic container structure does not have a degree of freedom, and is complicated. Moreover, with actuation of carriage, ink rocks violently and produces nonconformity in the regurgitation property of a recording head.

[0007] In order to solve this, the ink tank which contained the porosity member is proposed. On this ink tank, it has an injected hole for being filled up with ink, and an air hole for being open for free passage with atmospheric air so that air may flow corresponding to reduction by the activity of ink.

[0008] Moreover, in order to make it deaeration ink as mentioned above, ink is filled up with a reduced pressure condition and an ink tank is made to pack in a container in the state of reduced pressure further.

[0009]

[Problem(s) to be Solved by the Invention] However, in the conventional example, when whenever [ reduced pressure ] tends to be more large although it was good when the surface tension of ink was comparatively high and it was hard to foam, whenever [ deaeration ] tends to be maintained and it is going to raise dependability, or in the surface tension of ink is low and being easy to foam, ink leakage-comes to be easy from an injected hole. Moreover, if vacuum packaging is carried out after adding the impact of being as drop \*\*\*\*, since ink will leak by slight reduced pressure, workability is bad. If there is furthermore a temperature change, ink will

Publ'n No.: JP 07-266575 Publ'n Date: 17.10.1995

leak by expansion of the gas in ink. In order to prevent the leakage of ink, when the fill of ink is reduced and a charging efficiency is dropped, there is a problem that an ink tank becomes large. [0010] Moreover, even if it prepares space into an ink tank, or devises the configuration of a lid and copes with leakage, under hot environments, the gas in ink expands and leaks and preventing this thoroughly has the problem that an ink tank becomes large, in a difficult top.

[0011] Then, the place which this invention solves such a trouble and is made into the object has dependability in offering a small high ink jet recording device.

[0012]

[Means for Solving the Problem] In the ink jet recording device which the ink jet recording device of this invention supplies ink through a free passage member from an ink tank, and records an ink droplet on the discharge detail paper from a nozzle The free passage section which an ink tank opens for free passage to ink \*\*\*\*, ink \*\*\*\*, and a recording head, One piece thru/or two or more free passage holes dug so that it might be open for free passage with the exterior, and this each free passage hole are closed so that it may be in a reduced pressure condition. It is characterized by consisting of a container which consists of closure members of the non-permeability which can be opened just before at least one piece loads an ink jet recording device, prepares space further, and is packed in the state of reduced pressure.

[0013] In the ink tank which the ink tank of this invention loads with an ink droplet from a nozzle the ink jet recording device which records on the discharge detail paper, and supplies ink to a recording head The free passage section which an ink tank opens for free passage to ink \*\*\*\*, ink \*\*\*\*, and a recording head, One piece thru/or two or more free passage holes dug so that it might be open for free passage with the exterior, and this each free passage hole are closed so that it may be in a reduced pressure condition. It is characterized by consisting of a container which consists of closure members of the non-permeability which can be opened just before at least one piece loads an ink jet recording device, prepares space further, and is packed in the state of reduced pressure.

[0014] Ink \*\*\*\* which uses the manufacture approach of the ink tank of this invention for an ink jet recording device, In the manufacture approach of an ink tank of having the free passage section which is open for free passage to the free passage hole dug so that it might be open for free passage with the exterior, and ink \*\*\*\* and an ink jet recording device A. -- process C. which supplies and fills up an ink tank with the process B. ink which decompresses this ink \*\*\*\* through a free passage hole from a free passage hole -- by the closure member of the non-permeability which can open at least one piece It is characterized by consisting of a process which at least one piece puts in the process D. ink tank which seals by decompressing so that ink \*\*\*\* may be in a reduced pressure condition in a container without permeability, decompresses the inside of a container, and carries out a seal package among each free passage holes.

[0015] Moreover, said process of C and D is characterized by the thing of 0.02-0.05MPa mostly performed by this draft.

[0016] It is characterized by consisting of a process which carries out this stop of the closure member to un-sealing in the state of a tacking meal and reduced pressure under atmospheric pressure, and furthermore makes seal at least one of a free passage hole in the state of reduced pressure into a container.

[0017]

[Function] Since an ink tank is sealed in the state of reduced pressure, while ink is re-deaerated according to the above-mentioned configuration of this invention, the leakage of the ink in the time of vacuum packaging and transport or a state of preservation is lost. Moreover, since

vacuum packaging of the space was prepared and carried out between the ink tank and the hermetic container, from the interior of an ink tank, the gas which occurred in disassembly of ink is also gradually absorbed in vacuum packaging through a case, and, thereby, is deaerated by the very reliable condition in early stages of the activity of an ink tank. Nonconformity with the air which this mixes in an ink supply way at the time of exchange of an ink tank is canceled.

[0018] Moreover, since it can inspect visually before packing the decompressed ink tank, inspection between processes, such as ink leakage and deformation of a case, becomes easy.

[0019] Furthermore, the ink evaporation at the time of a real activity can be suppressed by covering the top face of the ink tank 7 by the closure member of non-permeability to the minimum.

[0020]

[Example] One example of this invention is explained based on a drawing below.

[0021] Drawing 1 is a main sectional view for explaining one example of the ink jet recording apparatus of this invention, and drawing 2 is the decomposition perspective view of the body of the ink tank used for the ink jet recording apparatus of this invention. Drawing 3 shows the perspective view of the body. Moreover, drawing 4 is a block diagram for explaining ink and a detector. A platen 1 is approached and the recording head 3 is formed in the carriage 2 which reciprocates a guide shaft 2a top in the direction of arrow-head B along with the platen 1 which is a recording paper conveyance means to rotate in the direction of arrow-head A in order to convey the recording paper in one. The ink tank 7 which held form 6a which there is ink \*\*\*\* 6 and becomes the interior from porosity members, such as polyurethane foam, is formed above the recording head 3. In this example, the ink tank 7 is divided into three chambers, 6Y, 6M, and 6C, and three ink \*\*\*\* 6 are formed. These chambers of each are filled up with yellow, cyanogen, and the color ink of a Magenta. However, if the class and number of ink change on a design, the number of chambers in the ink tank 7 will be divided into a required number. The exterior and the free passage hole 9 open for free passage are formed in the lid 8, and the base-like projection 10 which aims at adhesion with form 6a is formed in the base at the ink tank 7. There is the free passage section which turns caudad from the core of this projection 10, and is open for free passage to a recording head 3. The free passage section is formed in the edge of the ink room 11 which carries out ejection maintenance of the ink in form 6a, and the ink room 11 by the plug 12 which consists of elastic members, such as rubber. And by inserting in this plug 12 the hollow needle 5 which are a recording head 3 and a free passage member open for free passage through the filter room 4, it is constituted so that the ink which sank in into the ink tank 7 may be supplied to a recording head 3. In addition, the ink room 11 is in the condition of a sealing room by the plug 12 and form 6a. Moreover, it is closed till just before an activity by the closure member 21 of the non-permeability which at least one can open of the free passage hole 9, opens just before an activity, and is set to air hole 9a. However, although two or more free passage holes 9 are formed in this example, it is satisfactory for acquiring desired effectiveness at least each one chamber in any way. If the approach of pulling, removing and opening the edge using the closure member 21 long enough like drawing 2 is used in order to open, it can open easily. Furthermore, if the edge is joined into a container 25, when taking out from a container 25, it is surely opened, and there are also no problems, such as an opening failure of a user, and it can open certainly. Moreover, projection 31 is formed in the lever 30 for attaching an ink tank like drawing 5, and when attaching an ink tank, even if it uses the approach of breaking through a lever 30 by the derrick down and this projection 31 in the direction of C, it can open easily. However, if it is the configuration that the closure member 21 can be opened, it is not necessary

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to open using the instrument of dedication especially. The closure member 22 of non-permeability is formed in other free passage holes 9 which are not opened.

[0022] The reason for opening the closure member 21 here and opening air hole 9a is explained. The inside of an ink tank becomes negative pressure gradually as all the closure members 21 and 22 use a printer, since there are few air contents filled up in an ink tank to the ink consumption speed of the usual printer activity because of non-permeability. If this negative pressure exceeds constant value (i.e., if the negative pressure exceeding the capillary tube force of the meniscus of the ink formed in the nozzle of a head occurs in an ink tank), it will destroy and a meniscus will become the poor regurgitation of an ink droplet. Therefore, air hole 9a for filling up air corresponding to consumption of ink is needed.

[0023] Moreover, when the poor regurgitation arises in a recording head 3, ink should be attracted from a recording head 3 in operating a suction pump 15 through cap 13 and piping 14. Thereby, recovery action of the poor regurgitation is performed. The attracted ink is sent to waste ink \*\* 17 through piping 16. In this invention, waste ink \*\* 17 and the ink tank 7 are another objects, and waste ink \*\* 17 is arranged in the body of a recording device, and has the composition of usually not being exchanged.

[0024] By the way, the signs S1 and S2 in drawing are ink and an electrode for detection, the electrode S1 of one of these was formed in the internal surface of the ink tank 7 so that form 6a might be contacted, and the hollow needle 5 with which the electrode S2 of another side contacts ink serves as the electrode. O ring 24 made of rubber makes it have bit so that ink may not leak between an electrode S1 and the ink tank 7. And as shown in drawing 4, the seal of approval of the reference voltage Vcc is carried out to an electrode S1. Moreover, the hollow needle 5 which serves as the electrode S2 of another side is grounded. Furthermore, the resistance variation detector which consists of a differential circuit 19 and a comparison circuit 20 has connected with the electrode S1 of the side to which the seal of approval of the reference voltage Vcc is carried out. And when fixed level with resistance variation is exceeded, it is constituted so that an output signal may be generated.

[0025] Moreover, the record command signal for expulsion of an ink droplet by which a seal of approval is carried out to a recording head 3 is transmitted by FPC (Flexible Print Circuit) 18 which is a flexible signal means of communication. And on FPC18, ink and the signal line for detection are wired in one, and it connects with electrodes S1 and S2. In addition, the thing of FPC18 for which FFC (Flexible Flat Cable) etc. may be used for replacing cannot be overemphasized as a signal means of communication. It cannot be overemphasized that you may be the configuration of the two-sheet pile instead of FPC of one more sheet.

[0026] Next, the flow chart of drawing 6 explains the manufacture approach of the ink tank used for this example.

[0027] Like an ink tank erector, it leaves the closure members 21 and 22 and the ink tank 7 which consists of a configuration of above-mentioned drawing 2 is assembled.

[0028] At an ink \*\*\*\*\* reduced pressure process, it lets the free passage hole 9 pass, and ink \*\*\*\*\* 6 of the ink tank 7 is decompressed to 0.04 or less MPas. Whenever [ reduced pressure / at this time ] has 0.02 or less desirable MPas, when the amount of restoration ink and an injection time are taken into consideration.

[0029] Then, ink is filled up with an ink restoration process from the free passage hole 9. At this time, ink is decompressed and turns into deaeration ink. An ink packing effect is a very high approach as how to fill up ink with this reduced pressure condition into a porosity member is indicated and explained in JP,60-245560,A.



[0030] Next, \*\* is carried out except 9a by the closure member 22 among the free passage holes 9 under atmospheric pressure. Then, the ink tank 7 is made into the bottom of reduced pressure of 0.02-0.05MPa at a reduced pressure seal process, and \*\* is carried out for air hole 9a by the closure member 21. If it is under this reduced pressure, ink will be re-deaerated enough and there will be no ink leakage from air hole 9a. If whenever [ reduced pressure ] is set to 0.02 or less MPas, ink leakage will occur by few impacts after the ink leakage at the time of reduced pressure, or the above-mentioned seal, the position difference, environmental temperature change, etc.

[0031] After [ closure ] atmospheric-air disconnection is carried out. Like drawing 7 , this process may carry out 21b stop of the 21a of the closure member 21 under a tacking meal and reduced pressure of 0.02-0.05MPa under atmospheric air, and is easy this gentleman on equipment.

[0032] Thus, the ink of the sealed ink tank 7 is re-deaerated while homogeneity is filled up with the atmospheric-air disconnection and re-reduced pressure after restoration at form 6a of a porosity member.

[0033] Although the approach by joining or the binder etc. can be used for the closure approach, the joining is more desirable in order to prevent the leakage of ink. When using adhesives, it is necessary to satisfy the adhesive strength for preventing leakage, detachability, and the property of not being committed by ink.

[0034] It is the member of non-permeability, and the closure members 21 and 22 make a subject polyethylene terephthalate resin or an aluminum laminate film, and are joining or a laminated film which consists of polystyrene resin, polyolefine system resin, etc. so that it may be easy to paste up.

[0035] Next, in a reduced pressure packaging process, after putting the ink tank 7 and a spacer 28 into a container 25 like drawing 8 and decompressing to 0.02-0.05MPa, the seal of the seal section 26 is carried out thoroughly, and a seal package is carried out. Atmospheric-air disconnection is carried out after that.

[0036] Space 29 is between the ink tank 7 and a container 25. Even if ink decomposes during transport of the ink tank 7 and preservation and gas, such as nitrogen and oxygen, occurs, it is gradually deaerated through a case wall by this space 29. If the member to which air is penetrated like a corrugated fiberboard or urethane foam to a spacer 28, and space exists in the interior is used, even if a container 25 sticks, the space in a member will play the role of space 29. Moreover, a role of shock absorbing material which protects the ink tank 7 is also played. Whenever [ reduced pressure / at the time of vacuum packaging ] is the almost same 0.02-0.05MPa as whenever [ reduced pressure ] at the time of closure of said closure member 21. Pressure balancing in an ink tank and a hermetic container is maintained by this, and even if the bonding strength of joining or the closure members 21 and 22 which were pasted up is small on the ink tank 7, it does not separate.

[0037] The hermetic container by which the reduced pressure seal package was carried out is shown in drawing 9 . A container 25 is the package bag made from the very high aluminum laminate film of gas barrier property.

[0038] Furthermore, it is contained by the container 27 (un-illustrating) at a packing process. This condition was [ the seal section 26 of a container 25 ] of use in the container 27, and it serves as shock absorbing material. Therefore, it is not necessary to use a special buffer member.

[0039] Next, the relation between the degree of vacuum at the time of vacuum packaging and the nitrogen volume after the retention period in a vacuum-packaging condition is explained. What is

necessary is just to be able to control nitrogen volume, since nitrogen volume is the largest although gases other than nitrogen also exist in atmospheric air.

[0040] According to the experiment, by controlling whenever [ reduced pressure / at the time of a seal seal ] to be shown in a table 1, whenever [ deaeration / of the ink in the ink tank 7 immediately after opening a package ] is controllable.

[0041]

[A table 1]

[0042] The percentage of nitrogen volume which has melted into the ink to a saturation value had shown the nitrogen volume in a table, and, in the case of the ink used for this example, the saturation value was about 10-11 ppm.

[0043] Next, based on experimental data, drawing 10 explains how whenever [ in the ink tank from the time of manufacture to a real activity / ink deaeration ] changes to the nitrogen volume in ink. The ink deaerated at the a event after ink restoration reaches a saturation state by being left in an ambient condition at the b event of about three days after. If the ink tank 7 is sealed by the closure member 21 of non-permeability under reduced pressure of 0.02-0.05MPa at the c event, it will deaerate, nitrogen and oxygen of the dissolution in ink will be further absorbed by the space 23 of the ink tank 7, and ink will become by whenever [ deaeration / at the d event ]. Since ink decomposes and gas, such as nitrogen in an ink component, occurs after that, whenever [ deaeration ] falls. Although the period of d event is based also on a circumference environment, it is about one day and increases 10 to 20% at the e event over one year from six months. If vacuum packaging is carried out at the e event, whenever [ ink deaeration / of the ink tank 7 ] will improve gradually through the case of the ink tank 7 etc. Space 29 can be made to also absorb enough the gas from the ink generated during a long period of time. The period of e event to f event is a retention period in a package condition, and assumed two years in the experiment.

[0044] And nitrogen volume rises one by one from the event among [ after opening / f ] drawing. The nitrogen volume in ink will reach the abbreviation saturation state in [ g ] drawing after opening in about three days. However, according to the experiment, it turned out that the effectiveness by deaeration is expectable about two to four weeks after opening in [ f ] drawing (inside h of drawing). It will be in a perfect saturation state after that, and the effectiveness of deaeration of the ink for which it asks by this invention is lost.

[0045] Although each event established sufficient period and was performed in this experiment, in order to carry out closure at the c event under reduced pressure within several hours after the ink restoration at the a event and to perform vacuum packaging at the e event to a pan within one day in a real production process, it is N2 like a graphic display. A value change is not seen, but vacuum packaging is carried out where whenever [ deaeration ] is maintained enough.

[0046] Here explains the effectiveness by deaeration of ink. In case the ink tank 7 is taken out and inserted to the hollow needle 5, the amount of the air mixed from the hollow needle 5 is very

usually a minute amount. In the check by experiment, when the ink inflow aperture of the hollow needle 5 was a diameter of about 0.8mm, even if there were many amounts of the air to mix, they were below 0.4 cube mm extent for a meniscus. The air mixed once flows toward a recording head 3, and a trap is reached and carried out to filter 4a in the filter room 4 (un-illustrating). Since this air by which the trap was carried out has the very detailed eye granularity of filter 4a, filter 4a is not passed easily. When the diameter of filter 4a was [ the space width of face in 4mm and the filter room 4 ] about 0.3-0.5mm according to the experiment, even if the count of extraction and insertion of the ink tank 7 carried out 10 - ten numbers, this air did not pass filter 4a by record actuation. In case deaeration ink can be clearly supplied to a recording head 3 during the period to the inside g of drawing 10 if it is mixing of air of this level, and this takes out and inserts the ink tank 7 to the hollow needle 5, the air mixed from the hollow needle 5 melts into ink, and does not pose a problem. However, when left removing the ink tank 7 from the hollow needle 5 in a real activity, it is fully possible. In this case, air mixes in a large quantity. The air mixed when air mixed in the large quantity will close filter 4a, and will bar passage of ink. A recording head 3 becomes the poor regurgitation as the result. In this case, although the suction pump 15 was operated and recovery action of the poor regurgitation was performed, the experiment also showed that a big difference was in recoverability by whenever [ deaeration / of ink ]. If it is ink by about two - four weeks after opening shown in [ h ] drawing 10 , there will be no nonconformity in carrying out attraction clearance of the air in the filter room 4 with a suction pump 15 in any way. However, when it passed over this period, and it changed into the supersaturation condition further and filter 4a was passed with air, as for the air content in ink, it was checked full saturation and that apply to a recording head 3 from filter 4a, and minute air bubbles are generated. It will become the poor regurgitation when these minute air bubbles are in the pressure room of a recording head 3.

[0047] To the air mixed at the time of exchange of the ink tank 7 as explained above, nonconformity which becomes poor [ the regurgitation ] according to the effectiveness of deaeration of ink can be abolished. Moreover, also in the recovery action performed when air collects so much in the filter room 4, recovery action can be ended good according to the effectiveness of deaeration of ink. If the air content in the filter room 4 is below fixed, in order that air may not pass filter 4a with ink, even if it is ink used as the saturation state after among [ g ] drawing 10 , there is no nonconformity in any way at the time of recovery action.

[0048]

[Effect of the Invention] Since an ink tank is sealed in the state of reduced pressure, while ink is re-deaerated according to this invention, the leakage of the ink in the time of vacuum packaging and transport or a state of preservation is lost. Moreover, since vacuum packaging of the space was prepared and carried out between the ink tank and the hermetic container, the gas which occurred in disassembly of ink from the interior of an ink tank is also gradually absorbed in vacuum packaging through a case, and can supply the ink deaerated by the very reliable condition in early stages of the activity of an ink tank by that cause to a recording device. Nonconformity with the air which this mixes in an ink supply way at the time of exchange of an ink tank is canceled.

[0049] Moreover, since it can inspect visually before packing the decompressed ink tank, inspection between processes, such as ink leakage and deformation of a case, becomes easy.

[0050] Furthermore, it is effective in suppressing the ink evaporation at the time of a real activity to the minimum by covering the top face of the ink tank 7 by the closure member of non-permeability.

[0051] An ink jet recording device with it can be offered by the above. [ it is reliable and very, small ]

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## TECHNICAL FIELD

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[Industrial Application] This invention relates to the ink jet recording device which breathes out an ink droplet and records an alphabetic character etc. in the record paper from a nozzle.  
[0002]

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## PRIOR ART

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[Description of the Prior Art] From a nozzle, an ink droplet is made to breathe out, with the ink jet recording device which performs record writing, such as an alphabetic character according to recording information, ink is breathed out in the record paper from a detailed nozzle, and an ink droplet is formed in it. Formation of an ink droplet carries out volume change of the pressure room arranged in the interior of a recording head rapidly by electrostriction vibrator, an electric thermal-conversion component, etc., and is performed by generating a discharge pressure. Therefore, when air mixes in an ink supply path, a discharge pressure does not occur good but record writing becomes impossible.

[0003] Furthermore, record writing will become impossible, if all the ink in an ink tank is consumed and supply is cut off. And air enters in the ink supply path of resulting in a nozzle, and the problem of applying a great quantity of time amount and ink by the time record writing is attained, even if it newly supplies ink arises.

[0004] In order to cope with such a problem from the first, before arranging a level detector in an ink tank, or arranging a level detector in a part of ink supply path and cutting off supply of ink, the configuration which detects an ink end is used. It has prevented that air mixes in a large quantity in an ink supply path by that cause at ink and the time. However, it cannot prevent thoroughly that air mixes in an ink supply path at the time of extraction and insertion with the ink tanks at the time of exchange of an ink tank etc., and a recording head.

[0005] Then, what was indicated by JP,3-61592,B is known as a proposal for suppressing the effect of the air conventionally mixed in the ink supply path in first stage at the time of extraction and insertion with an ink tank and a recording head. The ink tank which held the deaerated ink in the very high hermetic container of gas barrier property is held in the state of reduced pressure. In this conventional example, immediately after opening a hermetic container, the ink in an ink tank is deaeration ink, and it is going to remove the effect of the air mixed in the ink supply path in this deaeration ink in first stage.

[0006] However, it is the position difference of an ink tank, a location, connectability, etc., and this hermetic container structure does not have a degree of freedom, and is complicated. Moreover, with actuation of carriage, ink rocks violently and produces nonconformity in the regurgitation property of a recording head.

[0007] In order to solve this, the ink tank which contained the porosity member is proposed. On this ink tank, it has an injected hole for being filled up with ink, and an air hole for being open for free passage with atmospheric air so that air may flow corresponding to reduction by the

activity of ink.

[0008] Moreover, in order to make it deaeration ink as mentioned above, ink is filled up with a reduced pressure condition and an ink tank is made to pack in a container in the state of reduced pressure further.

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## EFFECT OF THE INVENTION

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[Effect of the Invention] Since an ink tank is sealed in the state of reduced pressure, while ink is re-deaerated according to this invention, the leakage of the ink in the time of vacuum packaging and transport or a state of preservation is lost. Moreover, since vacuum packaging of the space was prepared and carried out between the ink tank and the hermetic container, the gas which occurred in disassembly of ink from the interior of an ink tank is also gradually absorbed in vacuum packaging through a case, and can supply the ink deaerated by the very reliable condition in early stages of the activity of an ink tank by that cause to a recording device. Nonconformity with the air which this mixes in an ink supply way at the time of exchange of an ink tank is canceled.

[0049] Moreover, since it can inspect visually before packing the decompressed ink tank, inspection between processes, such as ink leakage and deformation of a case, becomes easy.

[0050] Furthermore, it is effective in suppressing the ink evaporation at the time of a real activity to the minimum by covering the top face of the ink tank 7 by the closure member of non-permeability.

[0051] An ink jet recording device with it can be offered by the above. [ it is reliable and very, small ]

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## TECHNICAL PROBLEM

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[Problem(s) to be Solved by the Invention] However, in the conventional example, when whenever [ reduced pressure ] tends to be more large although it was good when the surface tension of ink was comparatively high and it was hard to foam, whenever [ deaeration ] tends to be maintained and it is going to raise dependability, or in the surface tension of ink is low and being easy to foam, ink leakage-comes to be easy from an injected hole. Moreover, if vacuum packaging is carried out after adding the impact of being as drop \*\*\*\*, since ink will leak by slight reduced pressure, workability is bad. If there is furthermore a temperature change, ink will leak by expansion of the gas in ink. In order to prevent the leakage of ink, when the fill of ink is reduced and a charging efficiency is dropped, there is a problem that an ink tank becomes large. [0010] Moreover, even if it prepares space into an ink tank, or devises the configuration of a lid and copes with leakage, under hot environments, the gas in ink expands and leaks and preventing this thoroughly has the problem that an ink tank becomes large, in a difficult top.

[0011] Then, the place which this invention solves such a trouble and is made into the object has dependability in offering a small high ink jet recording device.

## MEANS

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[Means for Solving the Problem] In the ink jet recording device which the ink jet recording device of this invention supplies ink through a free passage member from an ink tank, and records an ink droplet on the discharge detail paper from a nozzle The free passage section which an ink tank opens for free passage to ink \*\*\*\*, ink \*\*\*\*, and a recording head, One piece thru/or two or more free passage holes dug so that it might be open for free passage with the exterior, and this each free passage hole are closed so that it may be in a reduced pressure condition. It is characterized by consisting of a container which consists of closure members of the non-permeability which can be opened just before at least one piece loads an ink jet recording device, prepares space further, and is packed in the state of reduced pressure.

[0013] In the ink tank which the ink tank of this invention loads with an ink droplet from a nozzle the ink jet recording device which records on the discharge detail paper, and supplies ink to a recording head The free passage section which an ink tank opens for free passage to ink \*\*\*\*, ink \*\*\*\*, and a recording head, One piece thru/or two or more free passage holes dug so that it might be open for free passage with the exterior, and this each free passage hole are closed so that it may be in a reduced pressure condition. It is characterized by consisting of a container which consists of closure members of the non-permeability which can be opened just before at least one piece loads an ink jet recording device, prepares space further, and is packed in the state of reduced pressure.

[0014] Ink \*\*\*\* which uses the manufacture approach of the ink tank of this invention for an ink jet recording device, In the manufacture approach of an ink tank of having the free passage section which is open for free passage to the free passage hole dug so that it might be open for free passage with the exterior, and ink \*\*\*\* and an ink jet recording device A. -- process C. which supplies and fills up an ink tank with the process B. ink which decompresses this ink \*\*\*\* through a free passage hole from a free passage hole -- by the closure member of the non-permeability which can open at least one piece It is characterized by consisting of a process which at least one piece puts in the process D. ink tank which seals by decompressing so that ink \*\*\*\* may be in a reduced pressure condition in a container without permeability, decompresses the inside of a container, and carries out a seal package among each free passage holes.

[0015] Moreover, said process of C and D is characterized by the thing of 0.02-0.05MPa mostly performed by this draft.

[0016] It is characterized by consisting of a process which carries out this stop of the closure member to un-sealing in the state of a tacking meal and reduced pressure under atmospheric pressure, and furthermore makes seal at least one of a free passage hole in the state of reduced pressure into a container.

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## OPERATION

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[Function] Since an ink tank is sealed in the state of reduced pressure, while ink is re-deaerated according to the above-mentioned configuration of this invention, the leakage of the ink in the time of vacuum packaging and transport or a state of preservation is lost. Moreover, since vacuum packaging of the space was prepared and carried out between the ink tank and the hermetic container, from the interior of an ink tank, the gas which occurred in disassembly of ink

is also gradually absorbed in vacuum packaging through a case, and, thereby, is deaerated by the very reliable condition in early stages of the activity of an ink tank. Nonconformity with the air which this mixes in an ink supply way at the time of exchange of an ink tank is canceled.

[0018] Moreover, since it can inspect visually before packing the decompressed ink tank, inspection between processes, such as ink leakage and deformation of a case, becomes easy.

[0019] Furthermore, the ink evaporation at the time of a real activity can be suppressed by covering the top face of the ink tank 7 by the closure member of non-permeability to the minimum.

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## EXAMPLE

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[Example] One example of this invention is explained based on a drawing below.

[0021] Drawing 1 is a main sectional view for explaining one example of the ink jet recording apparatus of this invention, and drawing 2 is the decomposition perspective view of the body of the ink tank used for the ink jet recording apparatus of this invention. Drawing 3 shows the perspective view of the body. Moreover, drawing 4 is a block diagram for explaining ink and a detector. A platen 1 is approached and the recording head 3 is formed in the carriage 2 which reciprocates a guide shaft 2a top in the direction of arrow-head B along with the platen 1 which is a recording paper conveyance means to rotate in the direction of arrow-head A in order to convey the recording paper in one. The ink tank 7 which held form 6a which there is ink \*\*\*\* 6 and becomes the interior from porosity members, such as polyurethane foam, is formed above the recording head 3. In this example, the ink tank 7 is divided into three chambers, 6Y, 6M, and 6C, and three ink \*\*\*\* 6 are formed. These chambers of each are filled up with yellow, cyanogen, and the color ink of a Magenta. However, if the class and number of ink change on a design, the number of chambers in the ink tank 7 will be divided into a required number. The exterior and the free passage hole 9 open for free passage are formed in the lid 8, and the base-like projection 10 which aims at adhesion with form 6a is formed in the base at the ink tank 7. There is the free passage section which turns caudad from the core of this projection 10, and is open for free passage to a recording head 3. The free passage section is formed in the edge of the ink room 11 which carries out ejection maintenance of the ink in form 6a, and the ink room 11 by the plug 12 which consists of elastic members, such as rubber. And by inserting in this plug 12 the hollow needle 5 which are a recording head 3 and a free passage member open for free passage through the filter room 4, it is constituted so that the ink which sank in into the ink tank 7 may be supplied to a recording head 3. In addition, the ink room 11 is in the condition of a sealing room by the plug 12 and form 6a. Moreover, it is closed till just before an activity by the closure member 21 of the non-permeability which at least one can open of the free passage hole 9, opens just before an activity, and is set to air hole 9a. However, although two or more free passage holes 9 are formed in this example, it is satisfactory for acquiring desired effectiveness at least each one chamber in any way. If the approach of pulling, removing and opening the edge using the closure member 21 long enough like drawing 2 is used in order to open, it can open easily. Furthermore, if the edge is joined into a container 25, when taking out from a container 25, it is surely opened, and there are also no problems, such as an opening failure of a user, and it can open certainly. Moreover, projection 31 is formed in the lever 30 for attaching an ink tank like drawing 5, and when attaching an ink tank, even if it uses the approach of breaking through

a lever 30 by the derrick down and this projection 31 in the direction of C, it can open easily. However, if it is the configuration that the closure member 21 can be opened, it is not necessary to open using the instrument of dedication especially. The closure member 22 of non-permeability is formed in other free passage holes 9 which are not opened.

[0022] The reason for opening the closure member 21 here and opening air hole 9a is explained. The inside of an ink tank becomes negative pressure gradually as all the closure members 21 and 22 use a printer, since there are few air contents filled up in an ink tank to the ink consumption speed of the usual printer activity because of non-permeability. If this negative pressure exceeds constant value (i.e., if the negative pressure exceeding the capillary tube force of the meniscus of the ink formed in the nozzle of a head occurs in an ink tank), it will destroy and a meniscus will become the poor regurgitation of an ink droplet. Therefore, air hole 9a for filling up air corresponding to consumption of ink is needed.

[0023] Moreover, when the poor regurgitation arises in a recording head 3, ink should be attracted from a recording head 3 in operating a suction pump 15 through cap 13 and piping 14. Thereby, recovery action of the poor regurgitation is performed. The attracted ink is sent to waste ink \*\* 17 through piping 16. In this invention, waste ink \*\* 17 and the ink tank 7 are another objects, and waste ink \*\* 17 is arranged in the body of a recording device, and has the composition of usually not being exchanged.

[0024] By the way, the signs S1 and S2 in drawing are ink and an electrode for detection, the electrode S1 of one of these was formed in the internal surface of the ink tank 7 so that form 6a might be contacted, and the hollow needle 5 with which the electrode S2 of another side contacts ink serves as the electrode. O ring 24 made of rubber makes it have bit so that ink may not leak between an electrode S1 and the ink tank 7. And as shown in drawing 4, the seal of approval of the reference voltage Vcc is carried out to an electrode S1. Moreover, the hollow needle 5 which serves as the electrode S2 of another side is grounded. Furthermore, the resistance variation detector which consists of a differential circuit 19 and a comparison circuit 20 has connected with the electrode S1 of the side to which the seal of approval of the reference voltage Vcc is carried out. And when fixed level with resistance variation is exceeded, it is constituted so that an output signal may be generated.

[0025] Moreover, the record command signal for expulsion of an ink droplet by which a seal of approval is carried out to a recording head 3 is transmitted by FPC (Flexible Print Circuit) 18 which is a flexible signal means of communication. And on FPC18, ink and the signal line for detection are wired in one, and it connects with electrodes S1 and S2. In addition, the thing of FPC18 for which FFC (Flexible Flat Cable) etc. may be used for replacing cannot be overemphasized as a signal means of communication. It cannot be overemphasized that you may be the configuration of the two-sheet pile instead of FPC of one more sheet.

[0026] Next, the flow chart of drawing 6 explains the manufacture approach of the ink tank used for this example.

[0027] Like an ink tank erector, it leaves the closure members 21 and 22 and the ink tank 7 which consists of a configuration of above-mentioned drawing 2 is assembled.

[0028] At an ink \*\*\*\*\* reduced pressure process, it lets the free passage hole 9 pass, and ink \*\*\*\*\* 6 of the ink tank 7 is decompressed to 0.04 or less MPas. Whenever [ reduced pressure / at this time ] has 0.02 or less desirable MPas, when the amount of restoration ink and an injection time are taken into consideration.

[0029] Then, ink is filled up with an ink restoration process from the free passage hole 9. At this time, ink is decompressed and turns into deaeration ink. An ink packing effect is a very high



approach as how to fill up ink with this reduced pressure condition into a porosity member is indicated and explained in JP,60-245560,A.

[0030] Next, \*\* is carried out except 9a by the closure member 22 among the free passage holes 9 under atmospheric pressure. Then, the ink tank 7 is made into the bottom of reduced pressure of 0.02-0.05MPa at a reduced pressure seal process, and \*\* is carried out for air hole 9a by the closure member 21. If it is under this reduced pressure, ink will be re-deaerated enough and there will be no ink leakage from air hole 9a. If whenever [ reduced pressure ] is set to 0.02 or less MPas, ink leakage will occur by few impacts after the ink leakage at the time of reduced pressure, or the above-mentioned seal, the position difference, environmental temperature change, etc.

[0031] After [ closure ] atmospheric-air disconnection is carried out. Like drawing 7 , this process may carry out 21b stop of the 21a of the closure member 21 under a tacking meal and reduced pressure of 0.02-0.05MPa under atmospheric air, and is easy this gentleman on equipment.

[0032] Thus, the ink of the sealed ink tank 7 is re-deaerated while homogeneity is filled up with the atmospheric-air disconnection and re-reduced pressure after restoration at form 6a of a porosity member.

[0033] Although the approach by joining or the binder etc. can be used for the closure approach, the joining is more desirable in order to prevent the leakage of ink. When using adhesives, it is necessary to satisfy the adhesive strength for preventing leakage, detachability, and the property of not being committed by ink.

[0034] It is the member of non-permeability, and the closure members 21 and 22 make a subject polyethylene terephthalate resin or an aluminum laminate film, and are joining or a laminated film which consists of polystyrene resin, polyolefine system resin, etc. so that it may be easy to paste up.

[0035] Next, in a reduced pressure packaging process, after putting the ink tank 7 and a spacer 28 into a container 25 like drawing 8 and decompressing to 0.02-0.05MPa, the seal of the seal section 26 is carried out thoroughly, and a seal package is carried out. Atmospheric-air disconnection is carried out after that.

[0036] Space 29 is between the ink tank 7 and a container 25. Even if ink decomposes during transport of the ink tank 7 and preservation and gas, such as nitrogen and oxygen, occurs, it is gradually deaerated through a case wall by this space 29. If the member to which air is penetrated like a corrugated fiberboard or urethane foam to a spacer 28, and space exists in the interior is used, even if a container 25 sticks, the space in a member will play the role of space 29. Moreover, a role of shock absorbing material which protects the ink tank 7 is also played. Whenever [ reduced pressure / at the time of vacuum packaging ] is the almost same 0.02-0.05MPa as whenever [ reduced pressure ] at the time of closure of said closure member 21. Pressure balancing in an ink tank and a hermetic container is maintained by this, and even if the bonding strength of joining or the closure members 21 and 22 which were pasted up is small on the ink tank 7, it does not separate.

[0037] The hermetic container by which the reduced pressure seal package was carried out is shown in drawing 9 . A container 25 is the package bag made from the very high aluminum laminate film of gas barrier property.

[0038] Furthermore, it is contained by the container 27 (un-illustrating) at a packing process. This condition was [ the seal section 26 of a container 25 ] of use in the container 27, and it serves as shock absorbing material. Therefore, it is not necessary to use a special buffer member.

[0039] Next, the relation between the degree of vacuum at the time of vacuum packaging and the nitrogen volume after the retention period in a vacuum-packaging condition is explained. What is necessary is just to be able to control nitrogen volume, since nitrogen volume is the largest although gases other than nitrogen also exist in atmospheric air.

[0040] According to the experiment, by controlling whenever [ reduced pressure / at the time of a seal seal ] to be shown in a table 1, whenever [ deaeration / of the ink in the ink tank 7 immediately after opening a package ] is controllable.

[0041]

[A table 1]

[0042] The percentage of nitrogen volume which has melted into the ink to a saturation value had shown the nitrogen volume in a table, and, in the case of the ink used for this example, the saturation value was about 10-11 ppm.

[0043] Next, based on experimental data, drawing 10 explains how whenever [ in the ink tank from the time of manufacture to a real activity / ink deaeration ] changes to the nitrogen volume in ink. The ink deaerated at the a event after ink restoration reaches a saturation state by being left in an ambient condition at the b event of about three days after. If the ink tank 7 is sealed by the closure member 21 of non-permeability under reduced pressure of 0.02-0.05MPa at the c event, it will deaerate, nitrogen and oxygen of the dissolution in ink will be further absorbed by the space 23 of the ink tank 7, and ink will become by whenever [ deaeration / at the d event ]. Since ink decomposes and gas, such as nitrogen in an ink component, occurs after that, whenever [ deaeration ] falls. Although the period of d event is based also on a circumference environment, it is about one day and increases 10 to 20% at the e event over one year from six months. If vacuum packaging is carried out at the e event, whenever [ ink deaeration / of the ink tank 7 ] will improve gradually through the case of the ink tank 7 etc. Space 29 can be made to also absorb enough the gas from the ink generated during a long period of time. The period of e event to f event is a retention period in a package condition, and assumed two years in the experiment.

[0044] And nitrogen volume rises one by one from the event among [ after opening / f ] drawing. The nitrogen volume in ink will reach the abbreviation saturation state in [ g ] drawing after opening in about three days. However, according to the experiment, it turned out that the effectiveness by deaeration is expectable about two to four weeks after opening in [ f ] drawing (inside h of drawing). It will be in a perfect saturation state after that, and the effectiveness of deaeration of the ink for which it asks by this invention is lost.

[0045] Although each event established sufficient period and was performed in this experiment, in order to carry out closure at the c event under reduced pressure within several hours after the ink restoration at the a event and to perform vacuum packaging at the e event to a pan within one day in a real production process, it is N2 like a graphic display. A value change is not seen, but vacuum packaging is carried out where whenever [ deaeration ] is maintained enough.

[0046] Here explains the effectiveness by deaeration of ink. In case the ink tank 7 is taken out and inserted to the hollow needle 5, the amount of the air mixed from the hollow needle 5 is very usually a minute amount. In the check by experiment, when the ink inflow aperture of the hollow needle 5 was a diameter of about 0.8mm, even if there were many amounts of the air to mix, they were below 0.4 cube mm extent for a meniscus. The air mixed once flows toward a recording head 3, and a trap is reached and carried out to filter 4a in the filter room 4 (un-illustrating). Since this air by which the trap was carried out has the very detailed eye granularity of filter 4a, filter 4a is not passed easily. When the diameter of filter 4a was [ the space width of face in 4mm and the filter room 4 ] about 0.3-0.5mm according to the experiment, even if the count of extraction and insertion of the ink tank 7 carried out 10 - ten numbers, this air did not pass filter 4a by record actuation. In case deaeration ink can be clearly supplied to a recording head 3 during the period to the inside g of drawing 10 if it is mixing of air of this level, and this takes out and inserts the ink tank 7 to the hollow needle 5, the air mixed from the hollow needle 5 melts into ink, and does not pose a problem. However, when left removing the ink tank 7 from the hollow needle 5 in a real activity, it is fully possible. In this case, air mixes in a large quantity. The air mixed when air mixed in the large quantity will close filter 4a, and will bar passage of ink. A recording head 3 becomes the poor regurgitation as the result. In this case, although the suction pump 15 was operated and recovery action of the poor regurgitation was performed, the experiment also showed that a big difference was in recoverability by whenever [ deaeration / of ink ]. If it is ink by about two - four weeks after opening shown in [ h ] drawing 10 , there will be no nonconformity in carrying out attraction clearance of the air in the filter room 4 with a suction pump 15 in any way. However, when it passed over this period, and it changed into the supersaturation condition further and filter 4a was passed with air, as for the air content in ink, it was checked full saturation and that apply to a recording head 3 from filter 4a, and minute air bubbles are generated. It will become the poor regurgitation when these minute air bubbles are in the pressure room of a recording head 3.

[0047] To the air mixed at the time of exchange of the ink tank 7 as explained above, nonconformity which becomes poor [ the regurgitation ] according to the effectiveness of deaeration of ink can be abolished. Moreover, also in the recovery action performed when air collects so much in the filter room 4, recovery action can be ended good according to the effectiveness of deaeration of ink. If the air content in the filter room 4 is below fixed, in order that air may not pass filter 4a with ink, even if it is ink used as the saturation state after among [ g ] drawing 10 , there is no nonconformity in any way at the time of recovery action.

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## DESCRIPTION OF DRAWINGS

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[Brief Description of the Drawings]

[Drawing 1] The main sectional view for explaining one example of the ink jet recording device of this invention.

[Drawing 2] The decomposition perspective view of the body of the ink tank used for the ink jet recording device of this invention.

[Drawing 3] The perspective view of the body of the ink jet recording device of this invention.

[Drawing 4] The block diagram for explaining ink and a detector.

[Drawing 5] The perspective view of the body of the ink jet recording device of this invention.

[Drawing 6] The flow chart explaining the production process of this invention.

[Drawing 7] The perspective view explaining closure by the closure member of this invention.

[Drawing 8] The sectional view for explaining the inside of a reduced pressure container.

[Drawing 9] The perspective view for explaining the ink tank by which vacuum packaging was carried out.

[Drawing 10] Drawing having shown nitrogen volume and the relation of time amount.

[Description of Notations]

3 .... Recording Head

6 .... Ink \*\*\*\*\*

6a .... Form

7 .... Ink Tank

9 .... Free Passage Hole

9a .... Air hole

21 .... Closure member

22 .... Closure member

23 .... Space

25 .... Container

26 .... Seal section

28 .... Spacer

29 .... Space